






Work Order ID 52329



Tuesday, September 22, 2009 3:12:17 PM






Page 2

Item ID: D2731-3 Accept  Setup Start 
Revision ID: B Stop 
Item Name: Mounting Lug
Start Date: 9/23/2009 Start Qty: 40.00  Cust Item ID:
Required Date: 10/9/2009 Req'd Qty: 40.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	88	09/10/27		39.40	6		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BR	09-10-27		39			
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112260 Memo START TIME: 10:15 AM FINISH TIME: 10:45 AM	0.00 0.00	7	09/10/27		K39	5		

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Item ID: D2731-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Lug

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

PR 09-10-27

(39)

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 469

0.00



Packaging

Memo

0.00

Packaging

10/4/28 (39)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.09.10.28

MF 09-10-28

Picklist Print

Page 1

Tuesday, September 22, 2009 3:12:16 PM

Work Order ID: 52329



Parent Item: D2731-3RevB



Parent Item Name: Mounting Lug

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2731-3PRevB		Purchased	No			100	Each	0.0000	40.0000			
Lug												
D2423RevB1		Manufactured	No			110	f	684.6908	2.8758			
Lug Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

684.69078

43722

213.01468

44529

22.39

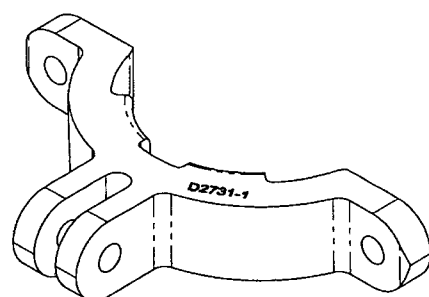
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449.2861

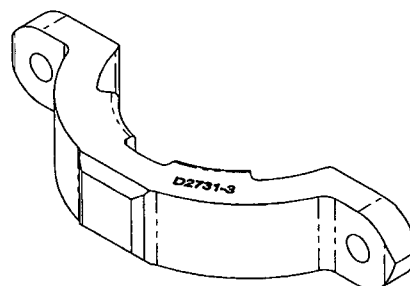
2.8758' on 09/10/24

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 32329

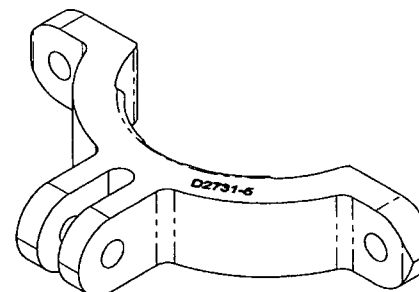
REUB



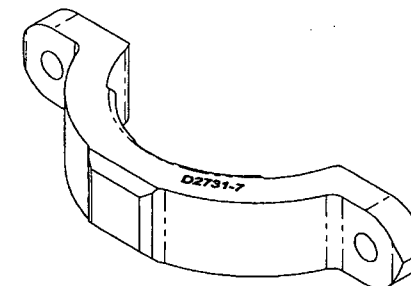
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

RELEASED
 09/07/19

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV: C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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8

7

6

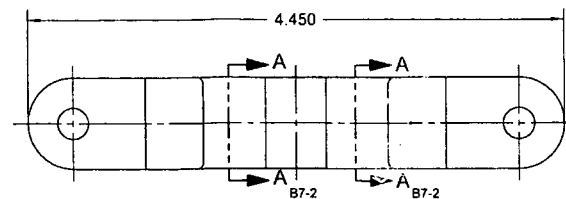
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4

3

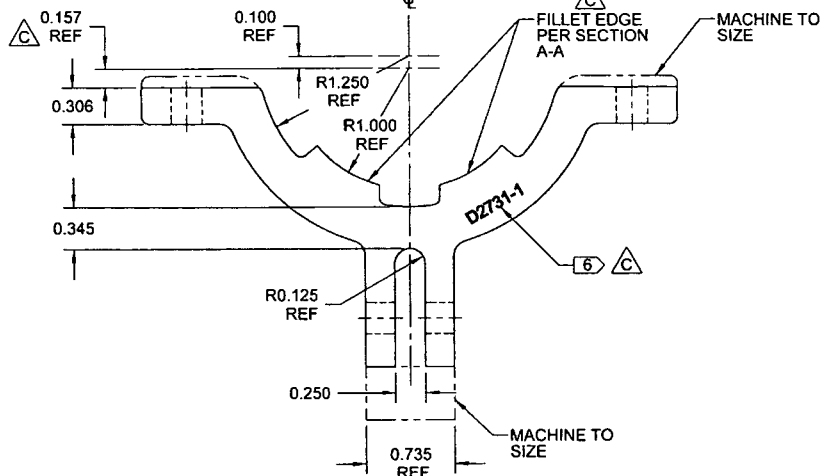
2

1



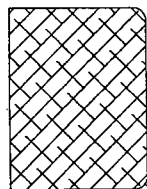
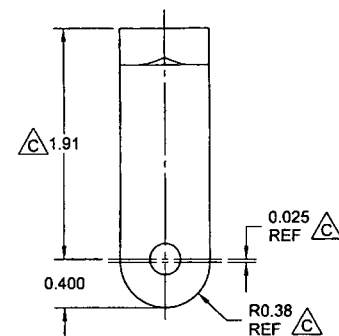
B7-2 B7-2

SYM ABOUT



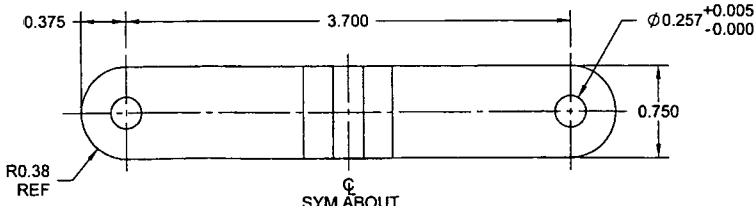
D2731-1 6

MACHINE TO SIZE



R0.06 MIN-R0.10 MAX 2 PL



SECTION A-A D4-2 SCALE 2X



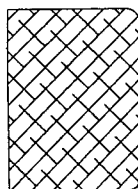
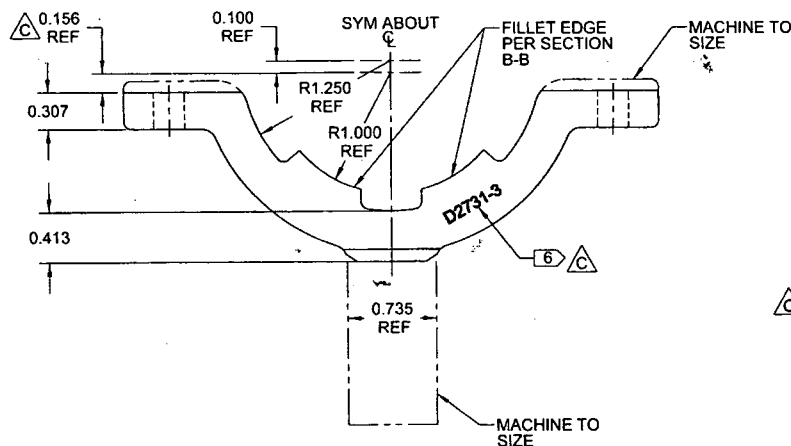
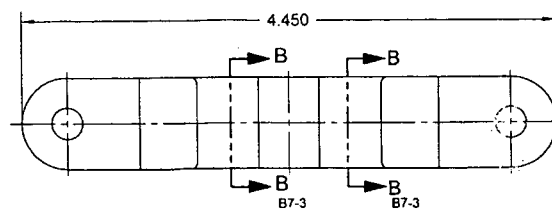
SYM ABOUT

D2731-1 MOUNTING LUG

RELEASED 09/06/25 AP

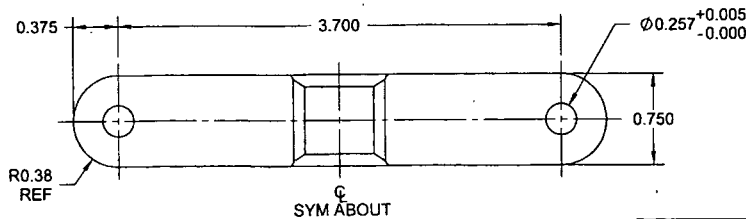
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MFG. APPR.		D2731	SHEET 2 OF 5
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8 7 6 5 4 3 2 1



R0.06 MIN-R0.10 MAX/
2 PL

SECTION B-B D4-3
SCALE 2X



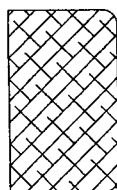
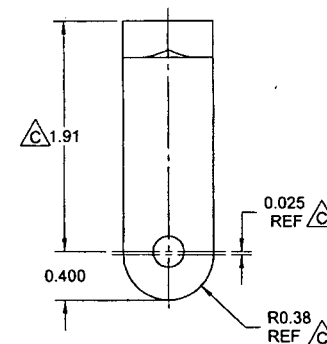
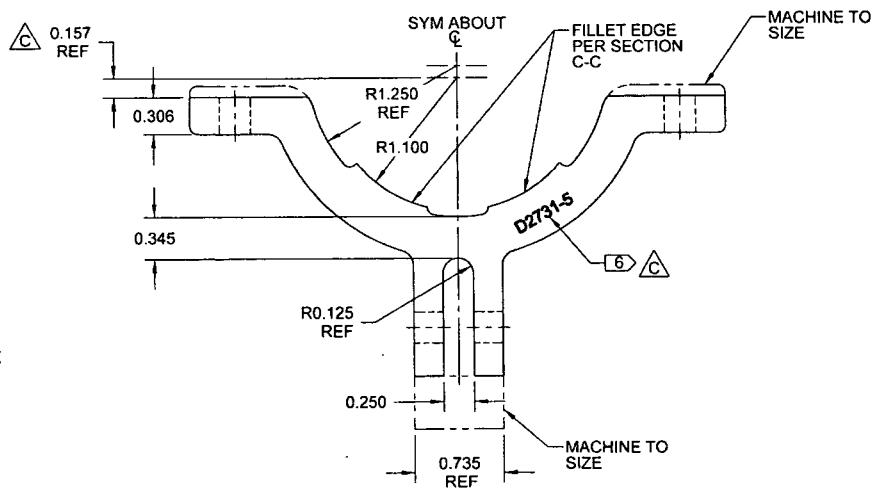
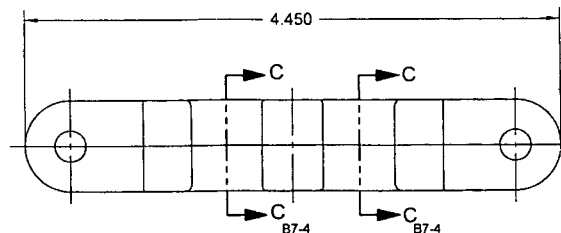
D2731-3 MOUNTING LUG

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07/06/25

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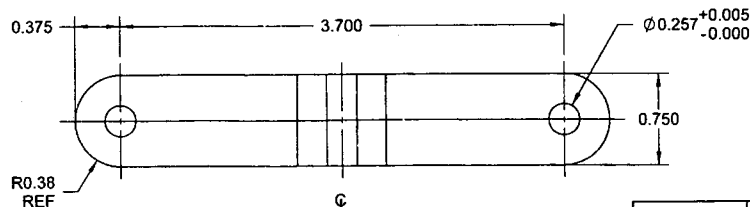
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SECTION C-C D44
SCALE 2X

R0.06 MIN-R0.10 MAX
2 PL



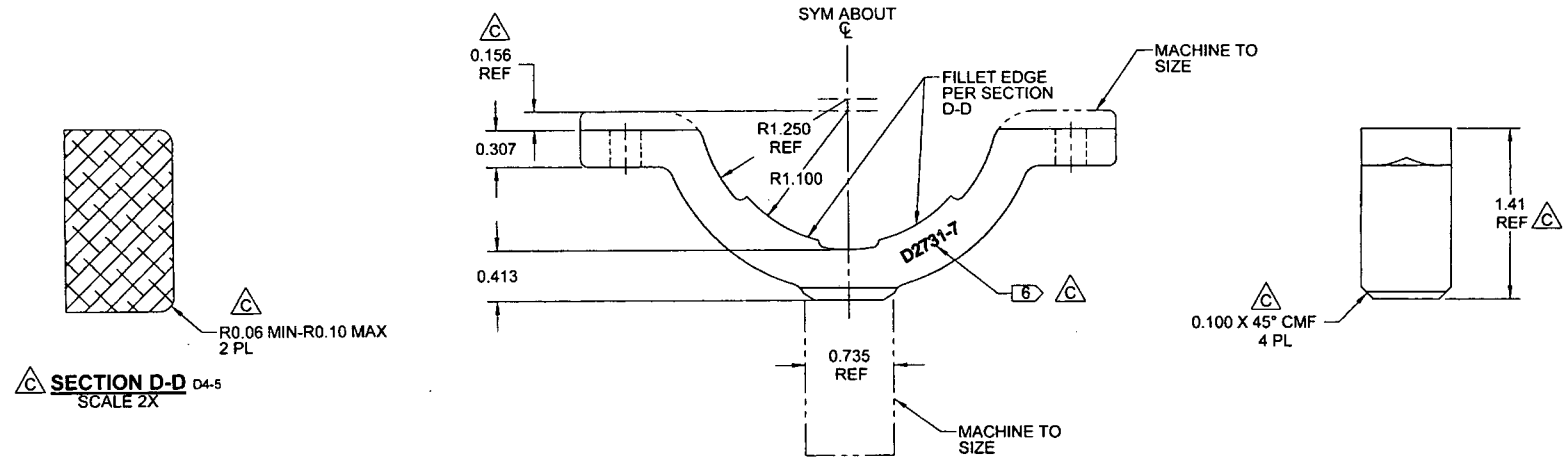
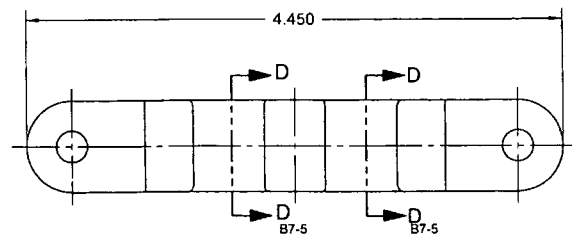
D2731-5 MOUNTING LUG

RELEASED
9/16/75

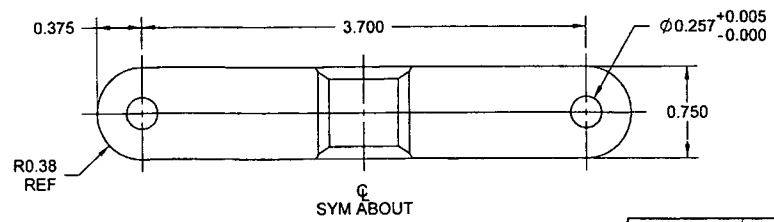
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



SECTION D-D D4-5
SCALE 2X



D2731-7 MOUNTING LUG

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09/06/25/10

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8 7 6 5 4 3 2 1

